



AMENDMENTS

Patent claims

1. (Currently Amended) A production machine comprising associated machine components including a drive, a control unit for controlling said drive, and detectors for determining at least two **a first and a second** variables fed to said control unit which are generated during the operation of the machine, wherein the control unit comprises a positional setpoint determination unit receiving said first variable **for generating a positional setpoint**, a correctional setpoint determination unit receiving said second variable and a **first and second** setpoint **for generating a correctional setpoint**, and a machine control unit receiving said positional setpoint and said correctional setpoint for generating a machine control parameter, wherein said correctional setpoint determination unit ~~generates~~ **selects either said** a first ~~and/or~~ second ~~correctional~~ setpoint depending whether a threshold of the first variable is exceeded **for generating said correctional setpoint from said selected setpoint and said second variable**.

2. (Original) A production machine according to claim 1 wherein the drive is selected from the group consisting of hydraulic, electric and a combination of hydraulic and electric.

3. (Currently Amended) An injection molding machine for the manufacture of plastic parts comprising an advancing screw for driving the injection and generating an injection pressure, said machine further comprising means for detecting and registering the injection pressure and position of said screw as measured variables during operation, ~~said~~

~~screw having~~ **and control means generating** at least one **speed variable from a** speed/displacement profile ~~variable~~ and a first and second **pressure variable from a** pressure profile ~~variable~~ wherein the at least one speed/displacement profile variable determines a setpoint value which can be counteracted by **a correction variable generated from** said first or second pressure ~~profile~~ variable depending on whether said position exceeds a predetermined threshold position.

4. (Withdrawn)

5. (Withdrawn)

6. (Currently Amended) The production machine according to claim 1 wherein the drive advances a screw for driving an injection and generating an injection pressure, and wherein the first variable is a position of said drive and the second variable is said injection pressure.

7. (Previously Presented) The injection molding machine according to claim 3 wherein the first pressure profile is pressure/displacement profile and the second pressure profile is a pressure/time profile.

8. (Previously Presented) The injection molding machine according to claim 7 wherein the speed/displacement profile and/or the pressure profiles can be predetermined.

9. (Withdrawn)

10. (Previously Presented) A method for the open-loop control of a production machine comprising the steps of:

- determining a positional setpoint from at least a first variable ;
- determining a correctional setpoint from a second variable and either a first or second setpoint depending whether a threshold of the first variable is exceeded, and
- generating a machine control parameter from said positional setpoint and said correctional setpoint.

11. (Previously Presented) The method according to claim 10, wherein the positional setpoint is determined by a speed/displacement profile, the first setpoint is determined by a pressure/displacement profile, and the second setpoint is determined by a pressure/time displacement..

12. (Withdrawn)

13. (Withdrawn)

14. (Canceled)

15. (Canceled)

16. (Canceled)

17. (Canceled)

18. (Withdrawn)

19. (Previously Presented) A production machine according to claim 1 wherein the correctional setpoint determination unit comprises a first setpoint determination unit receiving said first variable, a second setpoint determination unit receiving a third variable, a select unit controlled by said threshold for selecting said first or second setpoint as said setpoint.

20. (Previously Presented) A production machine according to claim 19 further comprising a subtraction unit for subtracting said second variable from said setpoint and a function unit for generating said correctional setpoint receiving an output signal from said subtraction unit.

21. (Previously Presented) A production machine according to claim 20 wherein the select unit further selects a first or second parameter set which is fed to said function unit.

22. (Previously Presented) The production machine according to claim 1 further comprising a mold, wherein the drive positions said mold and wherein the first variable is a position of said mold and the second variable is a mold closing pressure.

23. (Previously Presented)The production machine according to claim 1 further comprising an ejection mechanism, wherein the drive controls an ejection and wherein the first variable is a position of said ejection mechanism and the second variable is an ejecting force.

24. (Previously Presented)The method according to claim 11 wherein the first variable is the position of a mold and the positional setpoint is a function of the closing/opening speed and the second variable is a opening and/or closing pressure of the mold.

25. (Previously Presented)The method according to claim 11 wherein the first variable is the position of an ejection mechanism of a mold, the positional setpoint is a function of the speed of the ejection mechanism and the second variable is an ejection force of the ejection mechanism.